

Date: Monday, 02/02/2009 3:48:07 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASS'Y (A119)
Job Number	: 45427A		
Estimate Number	: 12445		
P.O. Number	:	Part Number	: D3515041
This Issue	: 02/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3515 REVA
First Issue	: / /	Project Number	: N/A
Previous Run	: 45426A	Drawing Revision	: A
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 15/03/2009
Checked & Approved By	: <u>JUD 01.02.09</u>	Qty:	1 Um: Each
Comment	: EST rev. A 06.06.05 Preliminary EC est B 07.04.09 revA dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D22321	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B39454

PD 09-03-13

2.0	D31663	Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Basket Hoop

Batch: B45941

PD 09-03-05

3.0	D23271	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B40390

PD 09-03-09

4.0	D2506	Label Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B44275

PD 09-03-13

5.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: B43800

PD 09-03-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/02/2009 3:48:08 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 45427A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: M110561

SAD 09-02-13 (D)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 (2) as per dwg D3516

2-Cut rib D3515-3 (2) as per dwg D3516

3-Cut rib D3515-5 (6) as per dwg D3516

4-Cut rib D3515-7 (3) as per dwg D3516

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

SAD 09-03-09 (D)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

PD 09-03-09

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-03-11

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-03-11 (D)

11.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M10992

SAD 09-03-12 (D)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 45427A

Part Number: D3515041

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

SAD 09-03-12

2-Cut expanded metal for base ends as per dwg D3516

SAD 09-03-12 ①

3-Weld expanded metal to base as per dwg D3516

PD 09-03-13

13.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

CP 09-03-13

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 15 ①

15.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M110939
Pressure wash

UMP/MS

09/03/16

1ST COAT:

START TIME: 10:00 AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 16:30 AM

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten signature

MS

09-03-16 ①

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/03/16

17.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per dwg

wing walk: M110454

black spray paint: M110907

MS

09-03-16

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



①

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/03/17

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

M 45 427

09/03/18 ①

20.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09/03/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

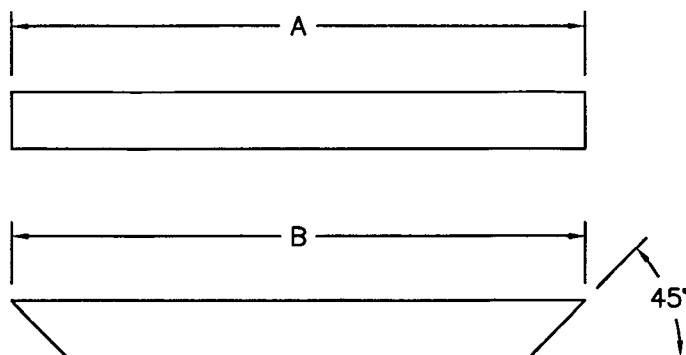
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

RELEASED06.11.17 *[Signature]***PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH	LENGTH	DESCRIPTION
		A	B	
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT

**D3515-1/-3/-5/-7**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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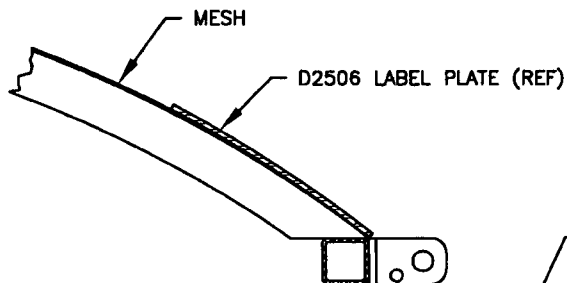
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RELEASED

06.11.17



SECTION A-A

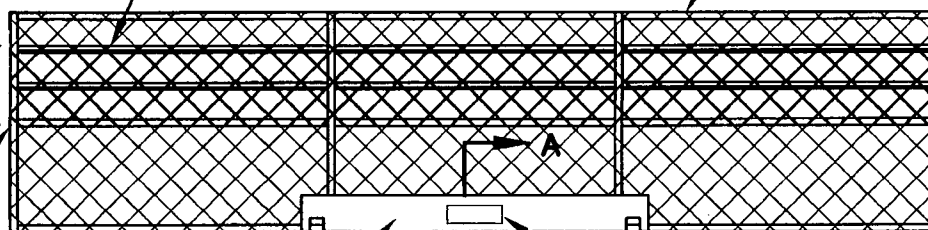
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT

TACK WELD MESH TO
FRAME AT EVERY AVAILABLE
LOCATION IN AREA TO BE
ANTI SKIDDED

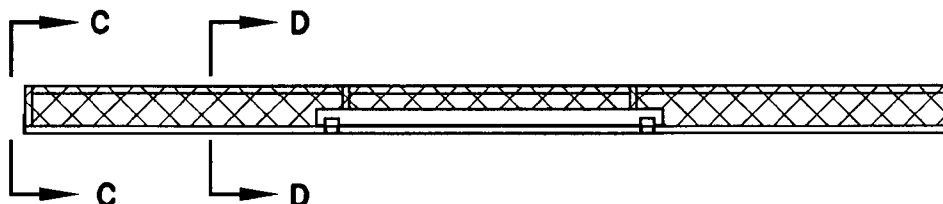
SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY



D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE



D3515-041 BASKET LID ASSEMBLY

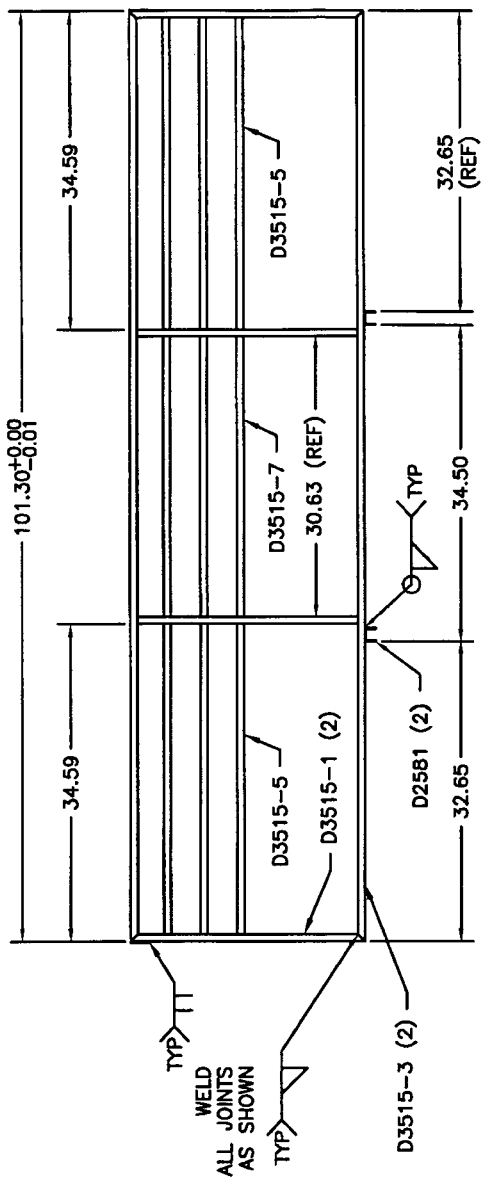
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE
- 5) APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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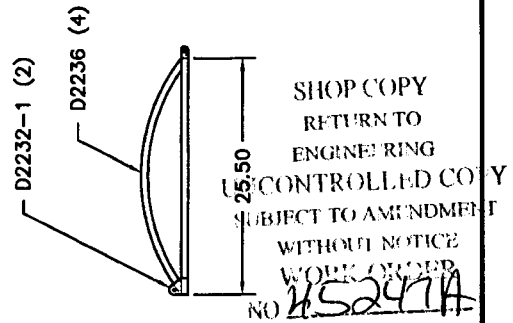
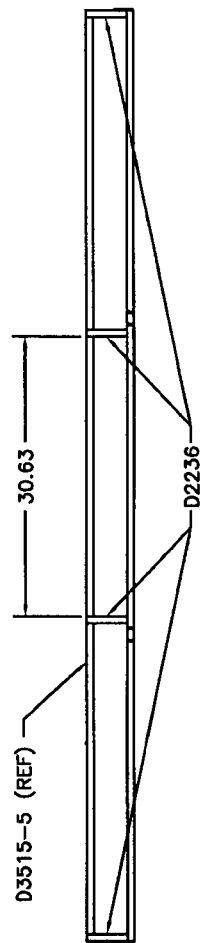
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
06.05.05	BASKET LID ASSEMBLY (A119)	SHEET 2 OF 4
		SCALE 1:20



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 3 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:20



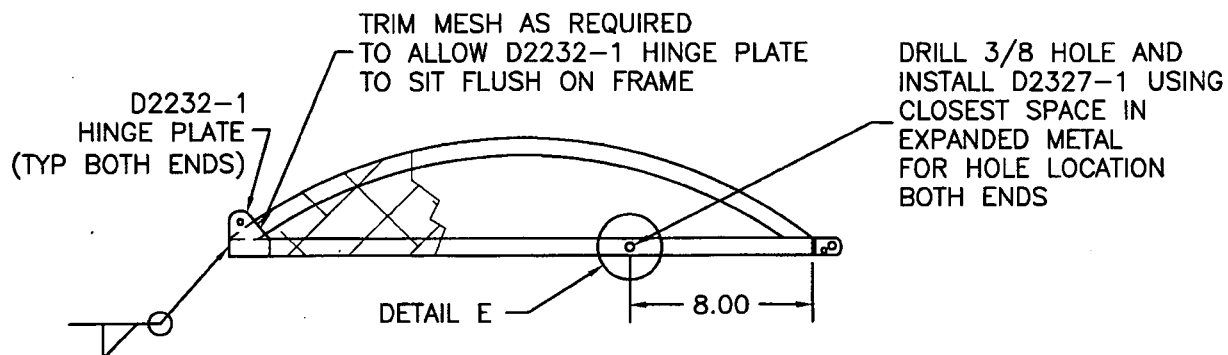
DETAIL B
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



RELEASED
06.11.17



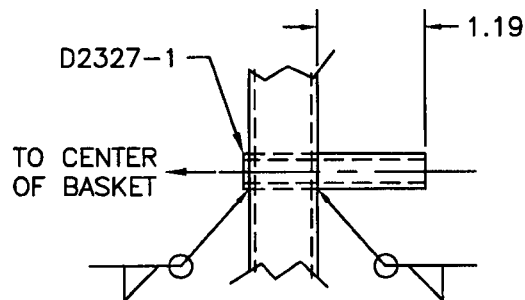
DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8



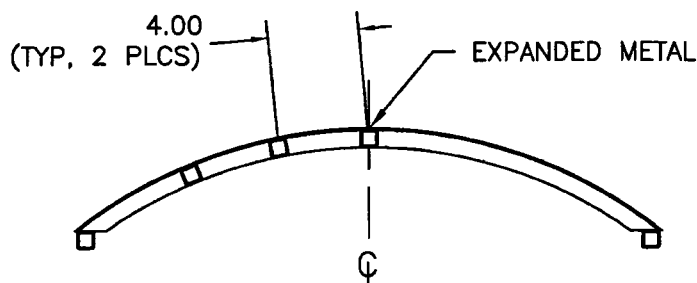
SECTION C-C SIMILAR BOTH END RIBS

RELEASED

06-11-07



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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RETURN TO
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NO. 45427H

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